

Horizontal Stretch Wrapping Machine

USER

MANUAL

CONTENT

I. Application Note.....	2
II. Important Alert.....	2
III. Technical Parameter.....	4
IV. Machine Installation.....	4
V. Machine Operation.....	5
VI. Operation Instruction.....	14
VII. Troubleshooting	16

Appendix:

Drawing of machine's layout

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I. APPLICATION NOTE

Wrapping is one of the most popular and widely used packaging method, such as pipe, tube, profiles, beverage, medicine, cosmetic, hardware, wood products, stationery, printing products, plastic products, glass products, electronic components, etc. single product, assembly packaging or collective packing available.

II. IMPORTANT ALERT

- ✧ Against operation regulation will cause serious consequences.
- ✧ Please make sure on grounding wires usage.
- ✧ Please turn off the power, air supply when the machine has emergency troubles, make sure it safe, and then clearance the troubles.
- ✧ Please do not change the native program and related settings.
- ✧ Please do not tear off the various signs on the machine.
- ✧ Please do not open the electrical box while the machine is working.
- ✧ When the machine is working, it is forbidden to place the hand and any other part of the body into the machine running parts.
- ✧ The packaged object must be pre-positioned before entering the machine to avoid deviating or falling into the body during the advance..

When the machine is working, it is forbidden to enter the inside of the machine.

Do not allow non-professional operators to operate the unit.

III. TECHNICAL PARAMETER

Item length	1500-7600mm
Item width	300-610mm
Item height	250-610mm
Item weight	100-1000kg
Packing material	PE film
Power	9kw
Power supply	480v/60Hz 3Phase
Air supply	6~8kgf/cm ²

IV. MACHINE INSTALLATION

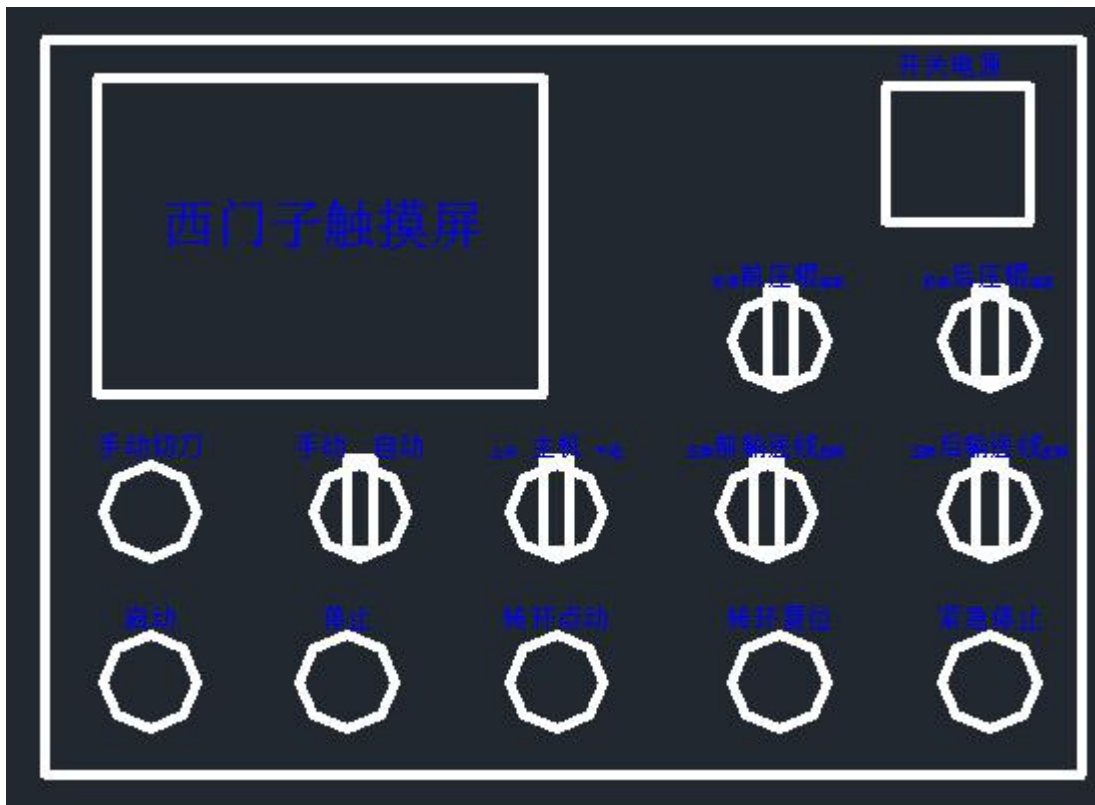
- ✧ This machine includes in-feeding conveyor, wrapping station, transition conveyor, out-feeding conveyor, protective covering and electrical box.
- ✧ Make these devices place on the ground and assemble some parts into the right position and direction. After that, adjust all the parts and devices relative position.
- ✧ In general, all the parts and devices are adjusted by the base of wrapping station placement.
- ✧ Please make sure all the conveyors at a same horizontal height.

- ✧ If it will wrap the shortest item, please try to make the out-feed conveyor closer to the wrapping station. It needs to adjust a nice distance of the conveyors and the station according to your real packing needs and site conditions.
- ✧ After all the mechanical parts installation and adjustment finish, it's time for air supply and power supply. **But before the supply**, install the **transformer**, otherwise it's dangerous for the machine to link it to the power supply. The machine inside lines is terminal blocks, please make sure all the block's numbers connect rightly. The air supply of the inside machine is quick plug. Just need make the corresponding air pipes, plugs connect correctly. Electrical drawing for reference.
- ✧ In the whole installation process, prevent injury, crush, crush, bumps and other types accident occurred.
- ✧ It is required that check carefully all the moving parts, because of long time transportation and move.
- ✧ The whole installation must be under the condition of the air supply and power supply off.
- ✧ The machine must be placed on the flat and hard ground.
- ✧ The ground load shall be greater than 5 tons /m².
- ✧ Non-professionals is forbidden when installation.
- ✧ Only if all the installation is finished, it's able to enter the next process.

- ◇ The machine placement should choose dry, clean environment.

V. PANEL INSTRUCTION

A. Buttons



MANUAL/AUTO MODE: the machine has MANUAL and AUTO working modes. MANUAL is usually to check and adjust the machine, clear the trouble and some given conditions. The AUTO mode is available for normal working.

MAINFRAME UP/DOWN: to control the mainframe to rise or go down.

F-CONVEYOR FWD/REV: to control the in-feed conveyor to forward or go back.

B-CONVEYOR FWD/REV: to control the out-feed conveyor to forward or go back.

PRESS ROLLER STRETCH/BACK: to control the press roller rise or go down.

MECHANICAL HAND FWD/BACK: to make the mechanical hand air cylinder forward or backward.

START: the machine will run in the manual mode.

STOP: to turn off the device running.

RING JOG: continue jog press the button to make the wrapping ring run slowly in the manual mode.

RING RESET: the ring will run slowly two circles and return to the original position after pressing.

MANUEL CUTTER: to cut the film in MANUAL mode.

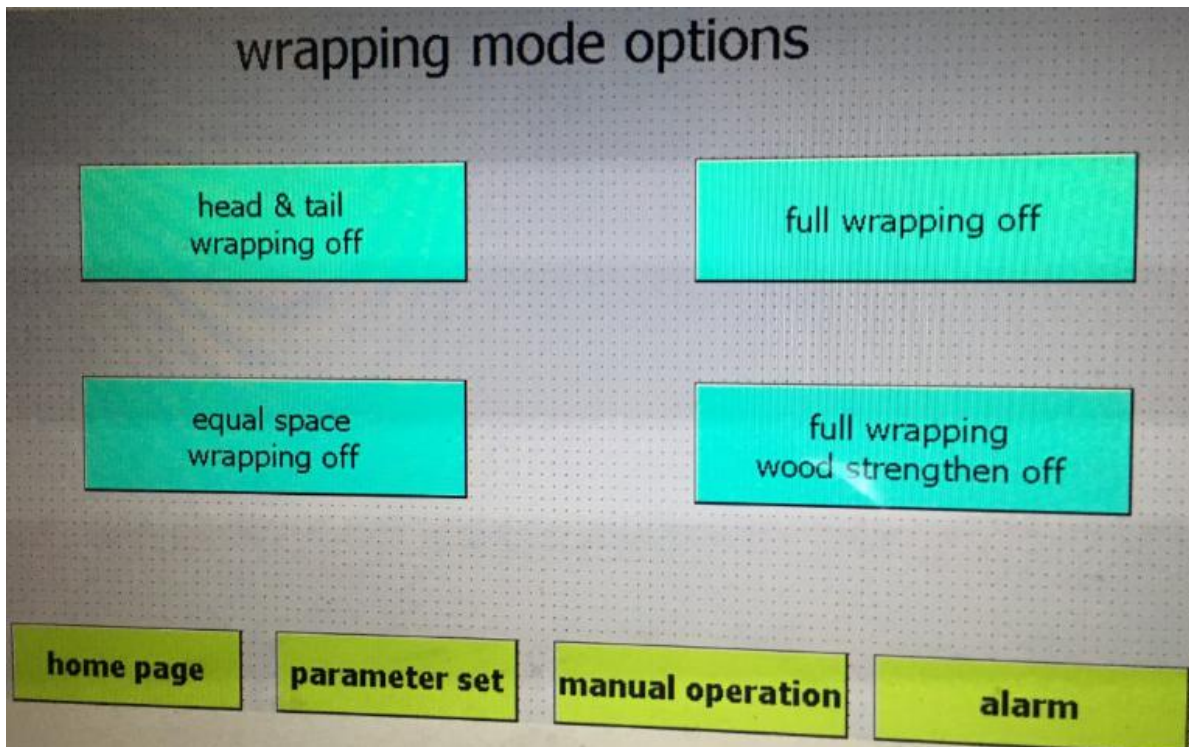
EMERGENCY STOP: the control switch of the circuit. The whole machine will stop when pressed.

POWER: the indicate light will be on when the control system is in the open condition.

B. Touch Screen

✧ Language choice page

✧ Wrapping mode options



HEAD & TAIL WRAPPING ON/OFF: this mode means just wrap the head and tail of the item. If ON, this mode affects. Click again, it's off.

FULL WRAPPING ON/OFF: this mode is to wrap the whole length of the item. If ON, this mode affects. Click again, it's off.

EQUAL SPACE WRAPPING ON/OFF: is to wrap at a certain space. If ON, this mode affects. Click again, it's off.

FULL WRAPPING WOOD STRENGTHEN ON/OFF: to wrap the item with the whole length, while it meets the wood, the wrapping layers will be more. If ON, this mode affects. Click again, it's off.

✧ Parameter set page

parameter set					
ring speed	000	HZ	ring speed+	ring speed-	
conveyor speed	000	HZ	head strengthen	000	circle
equal space	000	x0.1m	tail strengthen	000	circle
ring circles	000	circle	wood strengthen	000	circle
feed-out conveyor stop time	000	x0.1S	feeding-in delay	000	x0.1S
			feed-in conveyor tail delay	000	x0.1S
home page	wrapping mode options	manual operation	permissions page	alarm	

RING SPEED: to adjust the wrapping speed.

RING SPEED+: to speed on the ring, available for overlapping adjustment.

RING SPEED-: to speed down the ring, available for overlapping adjustment.

CONVEYOR SPEED: to control the conveyors speed. The speed is 40hz now.

If you need to adjust, please go to the PERMISSIONS PAGE.

EQUAL SPACE: to set the wrapping space or distance.

RING CIRCLES: to adjust the wrapping layers of the film (at least 4layers).

FEED-OUT CONVEYOR STOP TIME: to set the position of the wrapped item on the feed-out conveyor, especially for the short ones, because of the air cylinder of the mechanical length, convenient for the forklift working position.

HEAD STRENGTHEN: to add the film wrapping layer of the item head.

TAIL STRENGTHEN:to add the film wrapping layer of the item tail.

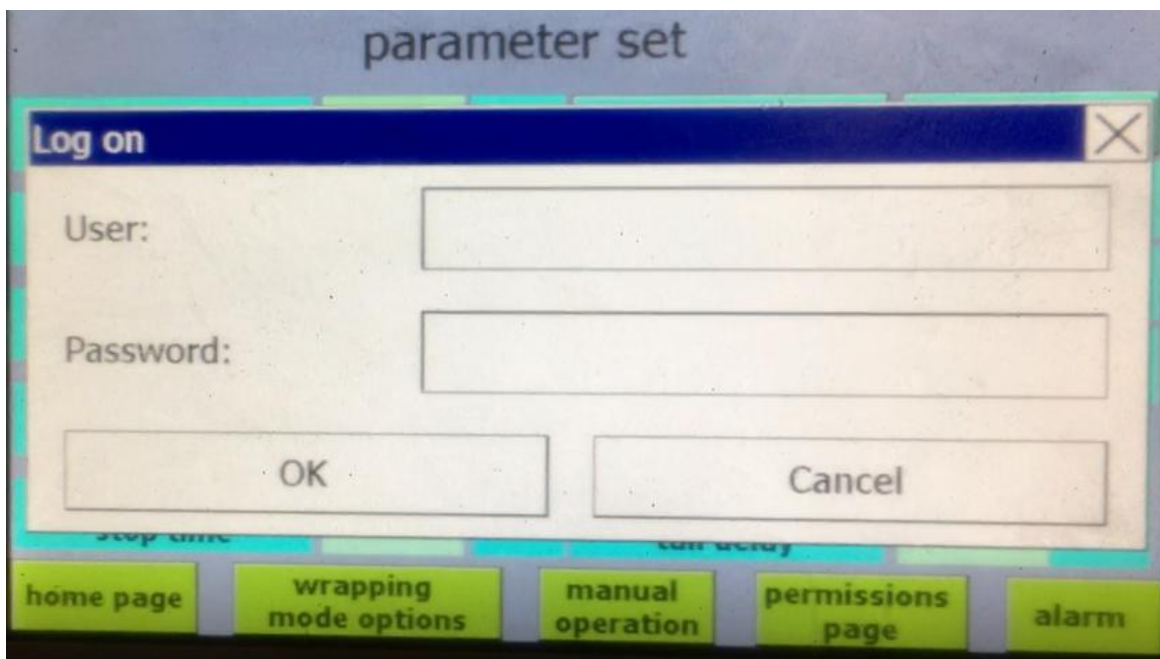
WOOD STRENGTHEN:to add the film wrapping layer when it meets the wood position.

FEEDING-IN DELAY: to set the item head distance with the ring to adjust the wrapping start position of the item. If the head distance with the ring shorter, the wrapping gap bigger.

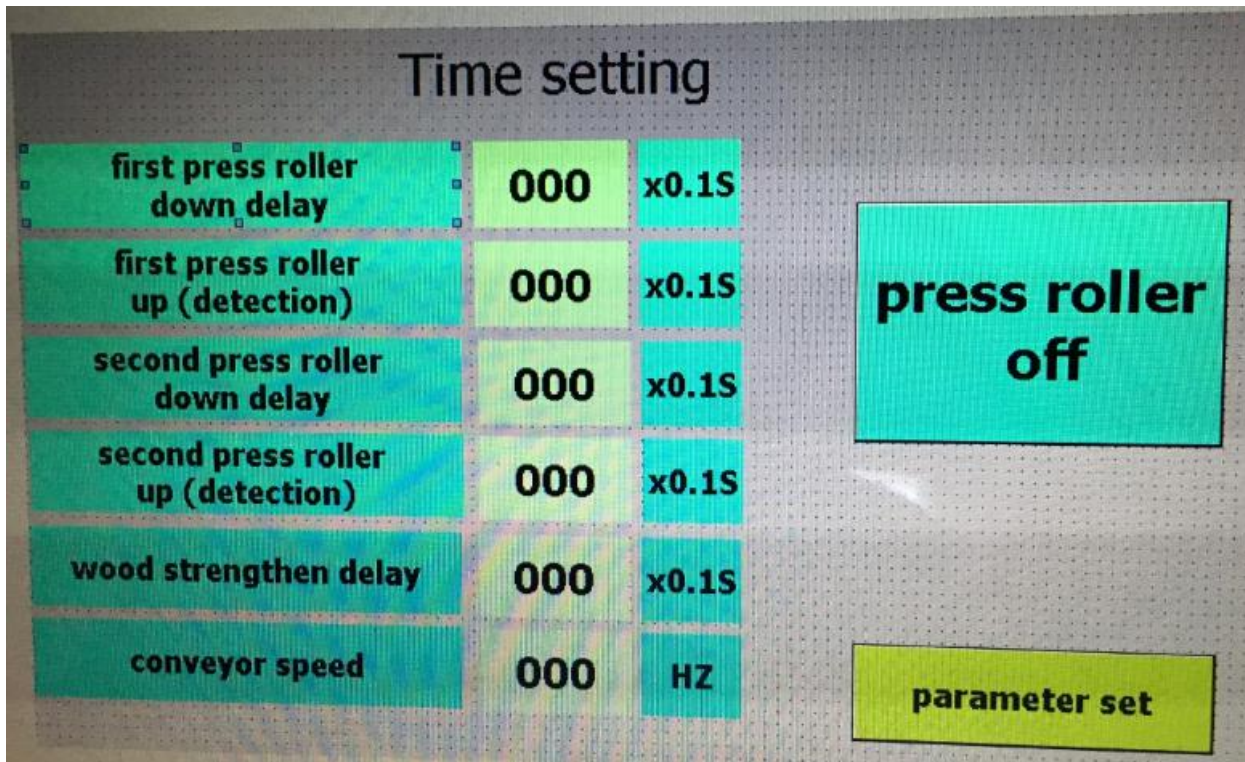
FEED-IN CONVEYOR TAIL DELAY:to set the item tail distance with the ring to adjust the wrapping start position of the item. If the number is bigger, the tail distance with the ring shorter, the wrapping gap smaller.

✧ Permission page

The sub-catalog is to set some not-common-used parameter, like CONVEYOR SPEED, PRESS ROLLER.



Type the code (123) and click the enter sign.



PRESS ROLLER ON: to control the press roller usage. If needed, please click again, it's PRESS ROLLER OFF.

FIRST PRESS ROLLER DOWN DELAY: to control the press roller on the F-conveyor go-down time.

FIRST PRESS ROLLER UP (DETECTION): to control the press roller on the F-conveyor go-down time when meeting with the wood, so as the wood go through safely.

SCEOND PRESS ROLLER DOWN DELAY:to control the press roller on the B-conveyor go-down time.

SECOND PRESS ROLLER UP (DETECTIN):to control the press roller on

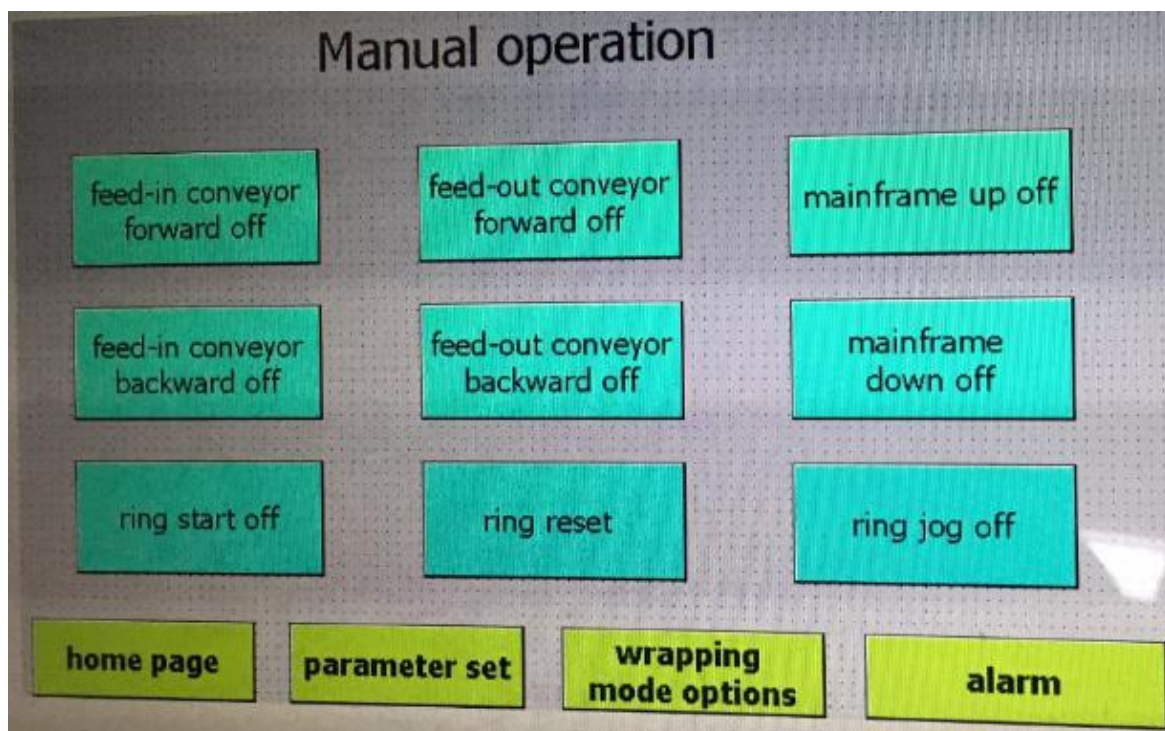
the B-conveyor go-down time when meeting with the wood, so as the wood go through safely.

WOOD STRENGTHEN DELAY: to control the wrapping time when meeting with the wood.

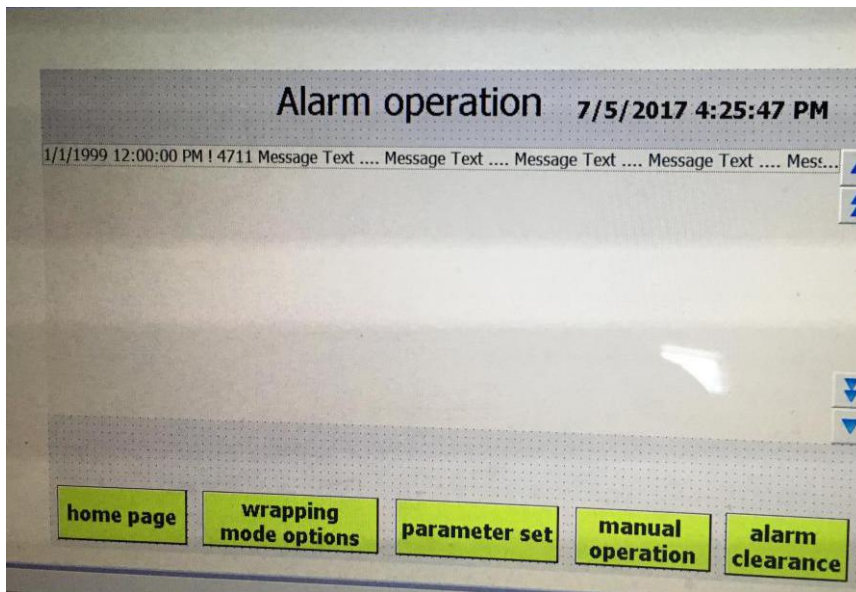
CONVEYOR SPEED: to adjust the conveyor speed.

Click the PARAMETER SET to exit.

✧ Manual operation page: the functions are the same as these buttons on the panel.



✧ ALARM page



C. Indicator light

The light will be on yellow when manual mode running.

The light will blink yellow when auto mode running.

The light will be blink red when troubles occur.

VI. OPERATION INSTRUCTIONS

Before the machine works, please check all the aspects carefully and meticulously and make sure the followings:

- ✧ The transformer is linked.
- ✧ the power and air supply normal;
- ✧ all the electric signals normal;
- ✧ the cutter in the reset condition;

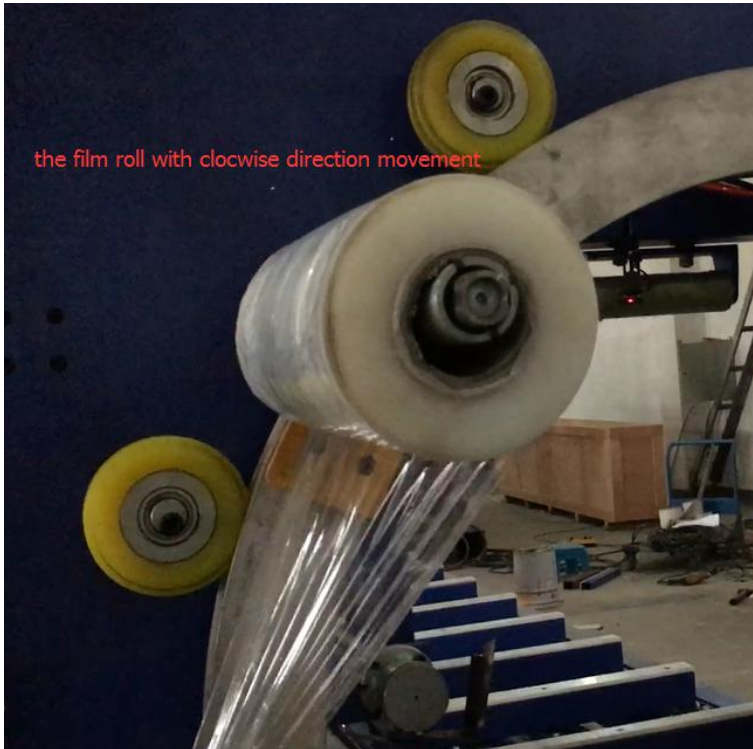
- ✧ the ring in the reset condition;
- ✧ The wrapping film normal and enough;
- ✧ the temperature of cutter;
- ✧ the regulating valve pressure setting of the air supply;
- ✧ adjust the press rollers height to meet with the item height;
- ✧ the touch screen and all the switches normal;

Here are the instructions.

- ✧ Link the transformer to the power supply
- ✧ Turn on the external power supply and air supply
- ✧ Switch on the POWER button on the panel.
- ✧ Place the film rolls with a right direction. Video for reference.



- 1) Press the RING RESET button after open the protective door.
- 2) Press the RING JOG button to adjust a nice position of the film roller.
- 3) Place the film roll with a right direction to make the film-releasing clockwise.



- 4) Place the holder (with a jack screw) and tighten.
 - 5) Press the RING RESET button and wait for the clamp not moving.
 - 6) Switch CLAMP FWD/BACK and make the tail of the film onto the clamp.
When the clamp goes back, let hand go. If you need to shorter tail, please cut it when the cutter forwards.
 - 7) Close the door.
- ✧ Feed in the item by forklift/hoisting.

✧ Automatic mode of 4 wrapping options. Please make sure all the buttons on the panel **non-operative** condition, MODE button can be MANUAL.

1) Head & Tail Wrapping

① Make this mode ON under the WRAPPING MODE OPTIONS page.

② Set and check the parameter on the PARAMETER SET according to your packing needs and item length, including RING SPEED, RING CIRCLES, FEED-OUT CONVEYOR STOP TIME, HEAD STRENGTHEN, TAIL STRENGTHEN, FEEDING-IN DELAY, FEED-OUT CONVEYOR TAIL DELAY.

③ Switch the MODE button to AUTO.

④ Press START button.

⑤ The item will pack automatically.

2) Equal Space Wrapping

① Make this mode ON under the WRAPPING MODE OPTIONS page.

② Set and check the parameter on the PARAMETER SET according to your packing needs and item length, including RING SPEED, RING CIRCLES, EQUAL SPACE, FEED-OUT CONVEYOR STOP TIME, FEEDING-IN DELAY, FEED-OUT CONVEYOR TAIL DELAY.

③ Switch the MODE button to AUTO.

④ Press START button.

⑤ The item will pack automatically.

3) Full Wrapping

- ① Make this mode ON under the WRAPPING MODE OPTIONS page.
- ② Set and check the parameter on the PARAMETER SET according to your packing needs and item length, including RING SPEED, RING CIRCLES, FEED-OUT CONVEYOR STOP TIME, FEEDING-IN DELAY, FEED-OUT CONVEYOR TAIL DELAY.

- ③ Switch the MODE button to AUTO.
- ④ Press START button.
- ⑤ The item will pack automatically.

4) Full Wrapping Wood Strengthen

- ① Make this mode ON under the WRAPPING MODE OPTIONS page.
- ② Set and check the parameter on the PARAMETER SET according to your packing needs and item length, including RING SPEED, RING CIRCLES, FEED-OUT CONVEYOR STOP TIME, WOOD STRENGTHEN, FEEDING-IN DELAY, FEED-OUT CONVEYOR TAIL DELAY.

- ③ Switch the MODE button to AUTO.
- ④ Press START button.
- ⑤ The item will pack automatically.

- ✧ Please move off the finished item after packing, ready to make next one room.
- ✧ If possible, please have a try several times with each mode and various length item to find a best parameter set.

VII. TROUBLESHOOTING

Trouble	Reason/Solution
The whole machine doesn't run, both manual and auto mode won't affect, too.	1、 check the external power supply, transformer and air supply. 2、 check the ALARM.
The film is easy to fall after running machine.	The film head is too loose to attach to the clamp.
The wrapping is too loose or burnt.	Adjust he film-releasing roller tension
The ring running is not smooth.	Adjust the ring running direction and make the friction wheels pressure uniform and moderate.

<p>The film wrapping performance is too closed or sparse.</p>	<p>Adjust the conveyor speed and ring speed to be suitable.</p>
<p>The item head and tail is left, not packing.</p>	<p>Please adjust the FEED-IN DELAY and FEEDING-IN CONVEYOR TAIL DELAY.</p>
<p>Alarm appears.</p>	<p>Please check and clear the circuit and overload conditions.</p>
<p>The mechanical hand air cylinder action abnormal.</p>	<p>Please check the air supply.</p>

Drawing of machine's layout:

